

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021981**Date Inspected:** 16-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

CWI Inspectors: Mr. Cui Zheng Hua, Mr. Man-Kit Li

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Bay 14

This QA Inspector observed ZPMC welder Mr. Wang Jinjiu stencil 043661 used shielded metal arc welding procedure specification WPS-345-SMAW-4G(4F)-FCM-Repair-1 to perform OBG segment 14E repair weld SEG3019Z-006. ZPMC QC informed this QA Inspector that weld repair document B-WR-20369 documents this weld repair. This QA Inspector measured a welding current of approximately 170 amps. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Zhao Guanglin, stencil 044779 used shielded metal arc welding procedure specification WPS-B-P-2214-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019N-112. This QA Inspector observed a welding current of approximately 175 amps, the base materials were preheated with a torch and Mr. Zhao Guanglin appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

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This QA Inspector observed ZPMC welder Mr. Kuai Wenshan, stencil 054013 used shielded metal arc welding procedure specification WPS-B-P-2214-TC-U4B-FCM-1 to make OBG segment 14E weld SEG3019N-115. This QA Inspector observed a welding current of approximately 180 amps, the base materials were preheated with a torch and Mr. Kuai Wenshan appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Wang Zhengbin, stencil 216086 used shielded metal arc welding procedure WPS-345-SMAW-3G(3F)-FCM-Repair-1 to make OBG segment 14E welds SEG3019P-083, 088 and 093. ZPMC QC informed this QA Inspector that weld repair document B-WR-20248 documents these weld repairs. This QA Inspector observed a welding current of approximately 175 amps the base materials were preheated with electrical heaters and Mr. Wang Zhengbin appeared to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents. See the photograph below for additional information.

This QA Inspector observed ZPMC welder Mr. Yang Yunfeng, stencil 215553 used shielded metal arc welding procedure WPS-345-SMAW-3G(3F)-FCM-Repair-1 to make OBG segment 14E welds SEG3019P-108 and 113. ZPMC QC informed this QA Inspector that weld repair document B-WR-20248 documents these weld repairs. This QA Inspector observed a welding current of approximately 185 amps the base materials were preheated with an electrical heater and Mr. Yang Yunfeng appeared to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Zhu Jibo, stencil 055564 used flux cored welding procedure WPS-B-T-2232-ESAB to make OBG segment 14E welds SEG3019C-046 through 049. This QA Inspector measured a welding current of approximately 320 amps, 25.0 volts, the base materials were preheated with an electrical heater and Mr. Zhu Jibo appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents. See the photograph below for additional information.



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Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey +8615000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
